

Date: Thursday, 4/5/2007 11:59:02 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING		
Job Number	: 31693					
Estimate Number	: 10823					
P.O. Number	: N/A		Part Number	: D23271		
This Issue	4/5/2007	S.O. No. : N/A	Drawing Number	: D2327 REV D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: 28334		Material	: N/A		
Written By	: <u>Johnston</u>		Due Date	: 4/22/2007		
Checked & Approved By	: <u>Johnston</u>		Qty:	50	Um:	Each
Comment	: Est. D 05.11.02 Removed 303 SS KJ/EC					
	Est Rev:E Removed 303SS JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0375	304 SS ROUND BAR	
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s) Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375)	Batch: <u>102301</u> BG 07.05.08 52
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr	BG 07.05.08 52
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	BG 07.05.08 52
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	BG 07/05/08 52
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<u>07/05/08 (52)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/09  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:59:02 AM  
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Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: SPACER BUSHING**

Job Number: 31693

Part Number: D23271

Job Number:



Seq. #: ... Machine Or Operation: ...

**Description :**

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④ 8785/09

### Job Completion



УФОСОР

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31693
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BS</u>	Audited by: <u>MJS</u>	Prototype Approval: N/A
Date: 07-05-08	Date: 07/05/08	Date: N/A

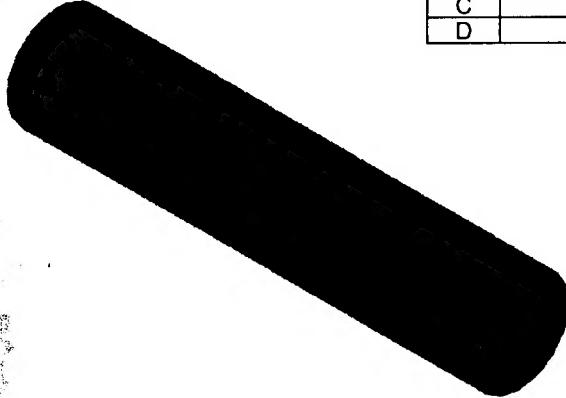
Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	RE

**DART**

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED CH	DRAWING NO. D2327
DATE 06.10.12		TITLE SPACER BUSHING

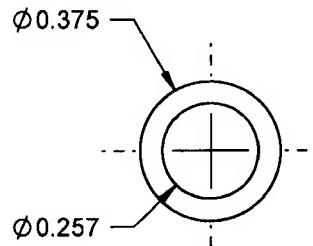
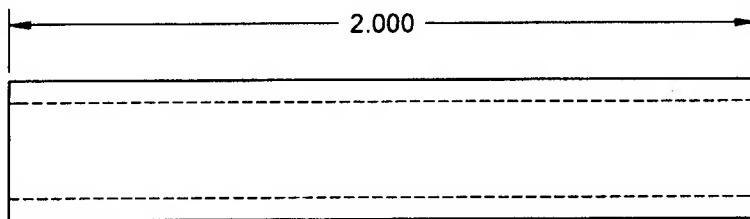
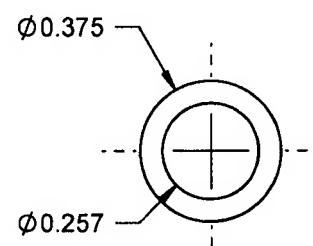
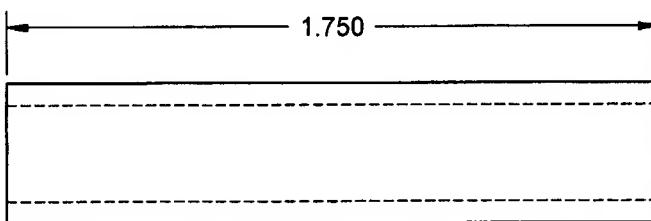
REV. D  
SHEET 1 OF 1  
SCALE  
2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL



RELEASED

06.11.14

**D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø 0.375, 0.065 WALL SEAMLESS ROUND TUBING  
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31693